

Work Order ID 153091

Tuesday, November 08, 2016 10:52:10 AM

153091

Page 1

Item ID: D4880-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206A/B FWD Leg Assembly, RH
Start Date: 11/30/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/8/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **NOV 09 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4880	C						DAS 6 9-89		
110		0.00							
110									
Small Fab									
Small Fab	Memo	0.33							
	ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-5 AND D4884-1. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9972 AS PER DWG.								
120		0.00							
120									
QC									
Quality Control	Memo	0.01							
	QC5- Inspect part completeness to step on W/O								

Pick Lt (2)

NOV 15 2016

2

FF

NOV 16 2016

DAS 38 9-89

NOV 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.01							
Packaging									
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.01							
Quality Control									
180	Identify as per dwg & Stock Location: 9230A	0.00							
180									
Packaging	Memo	0.00							
Packaging									

2x SP 16-11-24

2 DAS 38 9-89 NOV 24 2016

2 DAS 6 9-89 NOV 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89	NOV 24 2016	
190 QC	Memo	0.03							
Quality Control									

DAS
21
9-89 NOV 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
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OTHER : _____					

Picklist Print

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Work Order ID: 153091

153091

Parent Item: D4880-042

D4880-042

Parent Item Name: 206A/B FWD Leg Assembly, RH

Start Date: 11/30/2016

Required Date: 12/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

HL32PB5-12

Purchased

No

Each

51.0000

8

HI 32PB5-12

Hi-Lok Pin

**

NOV 15 2016

Location

Loc Qty

Loc Code

ST562

51

M129912

51

D4880-1

Manufactured

No

Each

0.0000

2

D4880-1

Strut

**

NOV 15 2016

D4883-5

Manufactured

No

Each

5.0000

2

D4883-5

End Fitting

**

NOV 15 2016

Location

Loc Qty

Loc Code

ST134

5

152487

5

D4884-1

Manufactured

No

Each

0.0000

2

D4884-1

End Fitting, Eye

**

NOV 15 2016

HL86-5

Purchased

No

Each

472.0000

8

HI 86-5

Hi-Lok Collar

**

NOV 15 2016

Location

Loc Qty

Loc Code

ST562

472

M129022

200

M129864

272

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

DQA: _____ Date: _____

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		OTHER : _____							



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34375

Purchase Order Date 11/18/2016

PO Print Date 11/18/2016

Page Number 1 of 2

Order From :
P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

VC-PL001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
NOV 18 2016

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613-931-1241	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
Ship Via:	FedEx Overnight collect	FOB	Destination-Collect
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	153106	D4880-041 LEG ASSEMBLY	11/23/2016 Yes 11/23/2016		2.00	\$4.00	\$8.00
ENGRAVE PART # D4880-041							
Line Total:							\$8.00
2	152722	D4880-042 LEG ASSEMBLY	11/23/2016 Yes 11/23/2016		1.00	\$4.00	\$4.00
ENGRAVE PART # D4880-042							
Line Total:							\$4.00
3	153091	D4880-042 LEG ASSEMBLY	11/23/2016 Yes 11/23/2016		2.00	\$4.00	\$8.00
ENGRAVE PART # D4880-042							

Note:

11/18/2016

SP 16-11-24.



19226 Airport Road
Summerstown, ON
K0C 2E0
plprinting@bellnet.ca

Tel.: 613 931-1241
Fax: 613 931-2560
www.plprinting.ca

Invoice

Number: 8791

Date: November 21, 2016

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
34375		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4880-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4880-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4880-042 ✓	2.00	4.00	✓	8.00
Laser Metal Marking, D4882-041	2.00	4.00	✓	8.00
				
Sub-Total				\$28.00
13.00% on 28.00				3.64
Total				\$31.64

DAS
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9-89

We do more than just print on paper!

*Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE November 21, 2016

P.O NUMBER PO34375

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4880-041 LEG ASSEMBLY	2	ALL ITEMS HAVE BEEN LASER MARKED
D4880-042 LEG ASSEMBLY	1	
D4880-042 LEG ASSEMBLY ✓	2	
D4882-041 LEG ASSEMBLY	2	

Sp/16-11-24.

DAS
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